

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000483**Date Inspected:** 04-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Hua Li Wei & CWI/QC Xu Bing			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** 114 Skin-C**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the random observations related to the following;

Item-1 114 Skin-C Cover pass 1, 2, 3 & 4. ZPMC technicians CAI Xin Xin and Zhou Dong Yun were visually monitored during their calibration of the magnetic particle (MT) yokes and the testing of the cover passes. Zhou Dong Yun tested welds 1 and 2 while Cai Xin Xin tested welds 3 and 4. Also tested were the areas where the lifting devices had been welded and ground smooth as well as each end of each weld. No relevant indications were noted by either of the ZPMC technicians and was signed for and accepted by ZPMC CWI Lu Jian Ping and visually accepted by CWI Hua Li Wei. Each cover pass tested was witnessed by the Caltrans QA Inspector and then approximately 50% of each weld was MT tested by the Caltrans QA Inspector and welds 1, 2 and 4 were found to be in compliance with project specifications while cover pass 3 had two areas where the cover pass was not tied into the base material. These areas were located from 502 mm to 504 mm and from 603 mm to 700.5 mm from the right edge of the plate and each were 1 mm in depth.

Right and left measurements were taken while standing on plate MUSC MA111-1 looking down at the number 3 weld. Indications were located at the toe of the weld nearest to the MA 111-1 plate. Each of the areas were marked with a yellow paint marker and the QC and CWI's made aware of their locations.

Summary of Conversations:

There were no conversations pertinent to this project that took place during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Smith,David	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
